



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW1205G00231-3G
Job Sheet 172630

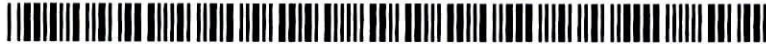


002671

Part No: RBW1205G00231-3G

Job Qty: 1 ea

Part Name: Main Rotor Damper Oil Filling Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW1205G00231-3G Rev 2B IPP Rev A 18.02.14m New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/15/18	0.00	0.00	Start Up Small Fab-4		SA
100	Small Fab	1 pcs		3/16/18	0.25	0.25	Small Fab-9		DAS FF
110	QC	1 pcs		3/16/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3-2		9-88
140	QC21-FG	1 Ea		3/16/18	0.00	0.00	QC21		GA102

Part Op 100 - Assemble as per DWG.

Descriptions: 130 - Identify and Stock

DAS
21
9-88

APR 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91611A108.52	Spring Pin 2mmRND x 18mm	82 Ea (2 ea)	90-Start up Operation	5004183
AN815-6D 5+325	Union M Flare	4 1Ea (1 ea)	90-Start up Operation	5041109
RBW1205G00231-3G-1-102	Body	4 1Ea (1 ea)	90-Start up Operation	5058565
RBW1205G00231-3G-3-	Tube	4 1Ea (1 ea)	90-Start up Operation	50536217
RBW1205G00231-3G-5-102	Pressure Relief Plug (Modified B/O)	4 1Ea (1 ea)	90-Start up Operation	50632842
RBW1205G00231-3G-7-	Washer	4 1Ea (1 ea)	90-Start up Operation	5063759
V75-010.36	Oring	82 Ea (2 ea)	90-Start up Operation	5038451
V75-011.36	Viton 75D Brown Oring	4 1Ea (1 ea)	90-Start up Operation	5038453
V75-013.36	Viton 75D Oring	4 1Ea (1 ea)	90-Start up Operation	5038452

Operation
90-Start up Operation



Container No: S064002

Part: RBW1205G00231-3G

Job No: 172630

Serial No/Batch: S064002

Revision: 2B
Inspector:

Date: 04/23/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Inventory	Allocated
206	0
31	0
0	0
0	0
0	0
0	0
0	0
50	0
50	0
50	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____									

Specifications could not be found.

Plex 2/21/18 8:37 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

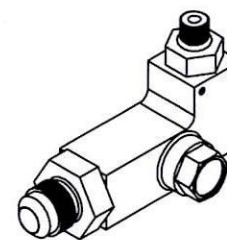
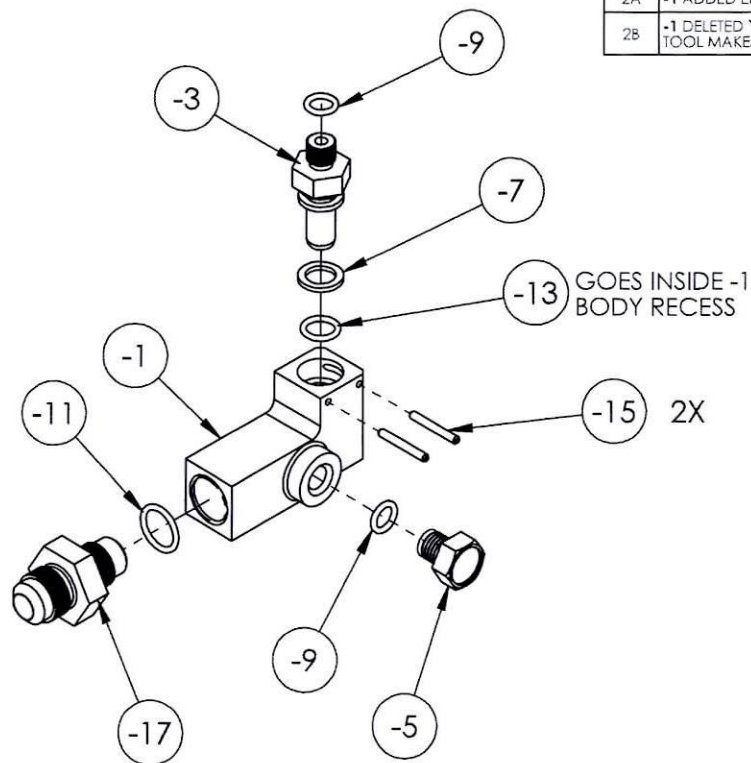
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OTHER : _____					

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REVISIONS					
REV	DESCRIPTION	DATE	INITIAL	APPROVED	
1	ADDED PART -17, -1 REMOVED 7/16-20 THREADED NIPPLE, MOVED RELIEF VALVE .100.	2/24/2011	JAG		
2	-1 CH'D TO USE PORTING TOOL 2 PLACES.	12/20/2011	JAG		
2A	-1 ADDED ENGRAVE NOTE PER S.E.	3/28/2012	RJC	SE	
2B	-1 DELETED $\nabla \phi .37 \times 90^\circ$, NEAR SIDE CALLOUT FROM 5/16-24 $\nabla .50$ BECAUSE 5/16-24 PORTING TOOL MAKES THIS FEATURE	1/21/2014	DPD	GE	



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172630 M.C
1802-21

FUNCTION: PART OF HELICOPTER SERVICING KIT T/N 3G1205G00131.
USED IN CONJUNCTION WITH A MANUAL HYDRAULIC OIL PUMP TO
RESTORE THE HYDRAULIC OIL LEVEL INTO THE M/R DAMPER

ORIGINAL No. REF
RBW1205G00231-3G = 3G1205G00231
RBW1205G00213-3G-1 = 3G1205G00651
RBW1205G00231-3G-3 = 3G1205G00551
DO NOT USE, FOR REGERENCE ONLY

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	1-1/8 X 1-3/8 X 2-3/16	2
			-3	1	TUBE	6061	Ø3/4 X 1-1/2	3
			-5	1	AN PRESSURE RELIEF PLUG	ALUMINUM	AIRCRAFT SPRUCE #AN814-2D (MODIFIED)	4
			-7	1	WASHER	NYLON	Ø1/2 X 3/16	5
		B/O	-9	2	O-RING	VITON	ID 1/4 X 1/16 WIDTH #V75-010	1
		B/O	-11	1	O-RING	VITON	ID 7/16 X 1/16 WIDTH #V75-013	1
		B/O	-13	1	O-RING	VITON	ID 5/16 X 1/16 WIDTH #V75-011	1
		B/O	-15	2	ROLL PIN	STEEL	Ø2mm X 18mm MCMaster-CARR #91611A108	1
		B/O	-17	1	FITTING	ALUMINUM	MS24392D6	1

RED BARN MACHINE			
TITLE MAIN ROTOR DAMPER OIL ADAPTER			
DWG NO. RBW1205G00231-3G			REV 2B
MAT'L		DRAWN BY: PERRITT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1		APPROVED <i>D. Wed</i>	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		HEAT TREAT FINISH SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL AGUSTA	
SCALE 1:2	DATE 2/23/2011	SHEET 1 OF 5	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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WORK ORDER NON-CONFORMANCE / UPDATE FORM NO. 100-001-001 REV. 10/01/00								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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